

• Date: Thursday, 11/06/2009 11:56:05 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 48499	
Estimate Number : 10713	
P.O. Number :	Part Number : D3213041 BK
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3213 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44163	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.06.11</u>	
Comment : Est Rev:A New Issue 05-11-17 17:27	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32163	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D32163-3	Hinge	<u>B44230</u> (37)

B46852 (6X)
B48513 (11X)

09/06/11

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-1	Door	<u>B44232</u>

09/06/11

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-3	Door	<u>B43622</u> (4P)

B44233 (6X)

09/06/11

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
24	MS20470AD4-4	Rivet	<u>M111193</u> (99X)

M111359 (79X)

M109631 (62X)

09/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:56:05 AM
User: Julie Dawson

Process Sheet

M109670

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48499

Part Number: D3213041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Eff 09/06/18 (10)
S 09/06/18 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:00am

OVEN TEMPERATURE:

320F

FINISH TIME:

8:30am

2H

09-06-22

(X10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Br 09-06-22 (10)

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

B43594 (1X)

B45851 (9X)

Eff 09/06/24

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

B47678 (3X)

B48527 (7X)

Eff 09/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:56:05 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48499

Part Number: D3213041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2462	Seal
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Comment: Qty.: 2.4000 f(s)/Unit Total : 24.0000 f(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D2462	Seal	B37747

EP09/06/24

12.0	D27281	Dart Logo label
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D2728-1	Decal	B39012

EP09/06/24

13.0	AN960JD6	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	AN960JD6	Washer	M6085

EP09/06/24

14.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	MS20470AD4-6	Rivet	M110915

EP09/06/24

15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

EP09/06/24 (10)

16.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

EP09/06/24 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:56:05 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48499

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 211

PC 8/6/24 (10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 JF

Job Completion



C209/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

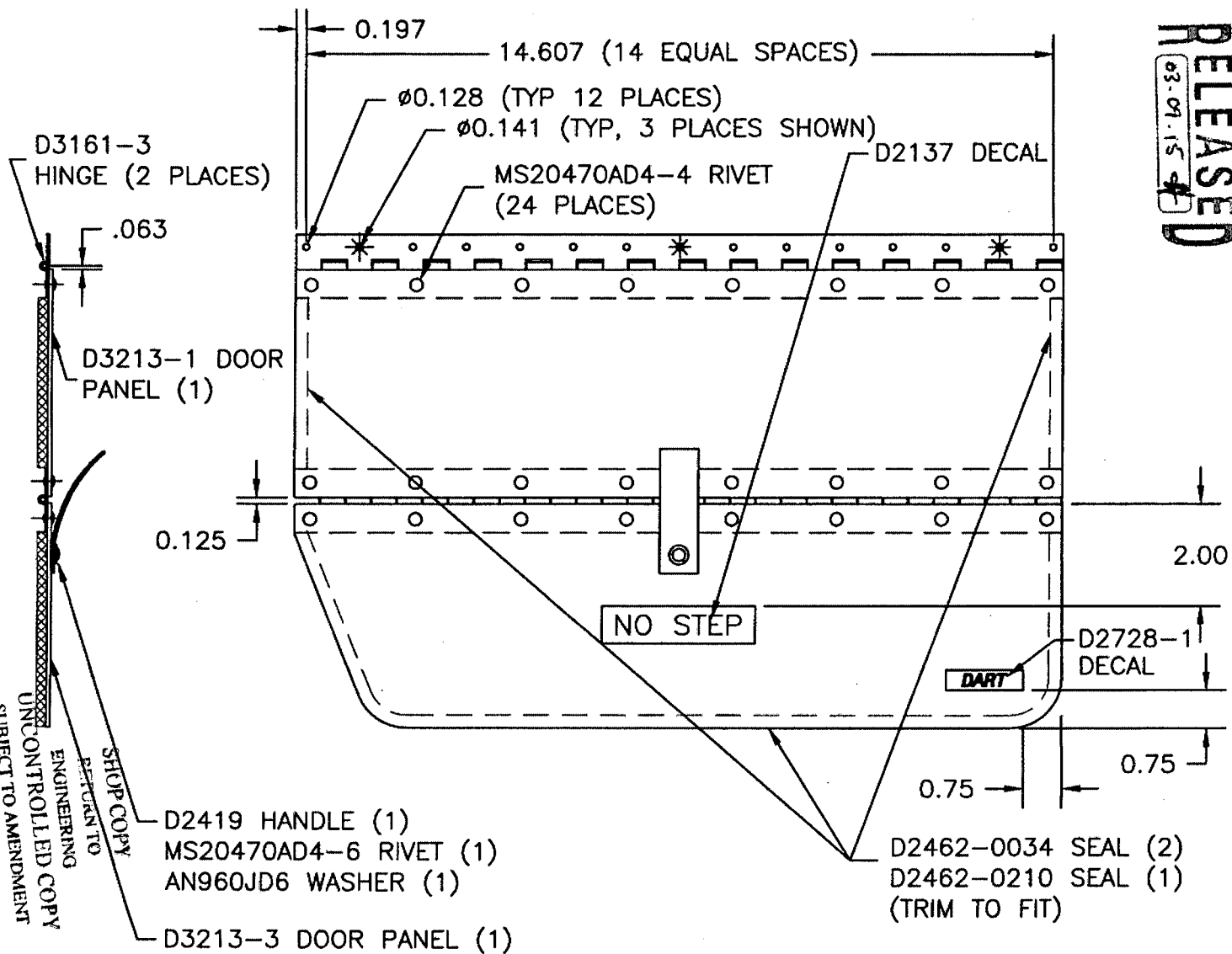
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA
03.09.03	03.09.03	03.09.03
CHECKED	APPROVED	DRAWING NO.
D3213	D3213	D3213
DATE	TITLE	REV. A
03.09.03	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3

RELEASED
03-09-15



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

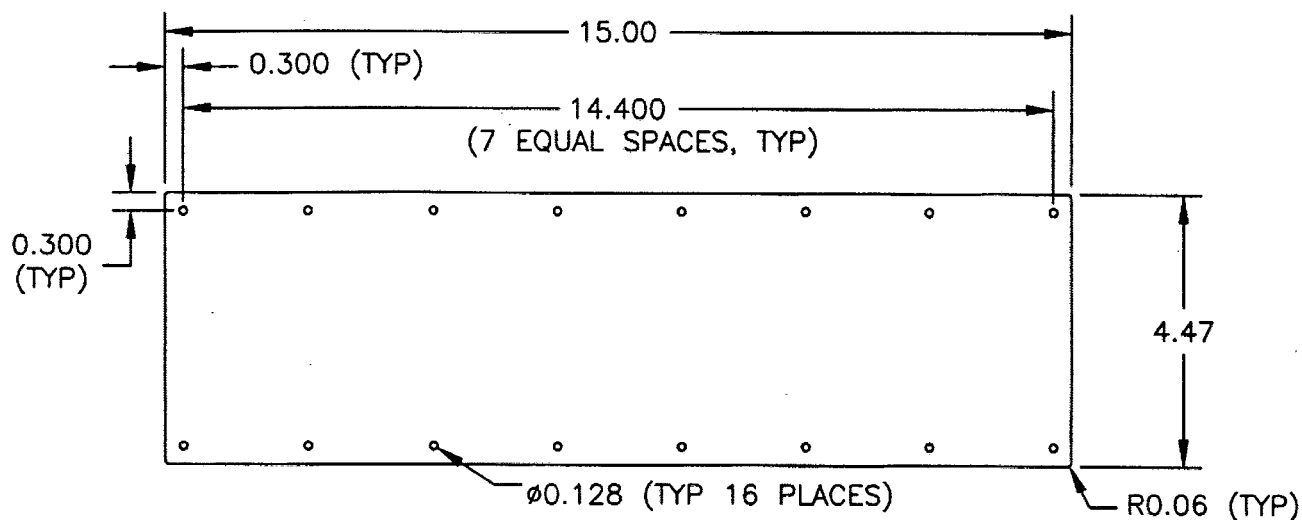
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

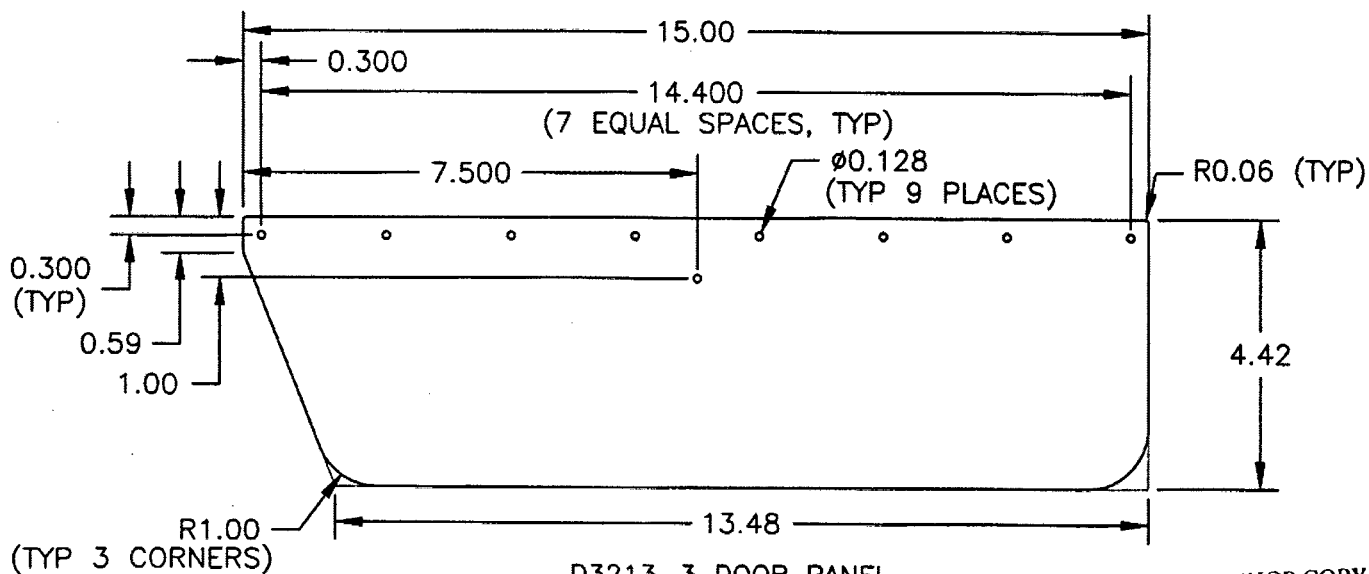
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

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CONTROLLED COPY
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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